

Date: Tuesday, 4/18/2006 10:07:16 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TUBE ASSEMBLY
<b>Job Number</b> :	26693		
<b>Estimate Number</b> :	10429		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3304043
<b>This Issue</b> :	4/18/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3304 REV. B
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26668	<b>Drawing Revision</b> :	B
		<b>Material</b> :	N/A
		<b>Due Date</b> :	5/20/2006
<b>Written By</b> :			<b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	[Signature] 06.04.18		
<b>Comment</b> :	Est: D 04.11.26 Revised Step 7 KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0875W065	SS TUBING
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**Comment:** Qty.: 1.9469 f(s)/Unit Total : 7.7876 f(s)

Material: AISI 304/316 SS tubing 0.875" x 0.065" wall

(M304TR0.875W.065)

Batch: 116258

06/06/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1- Cut blank: 22.00" as per Dwg D3304

2- Turn as per Folio FA458 and Dwg D3304

3- Deburr

N/A Machined Manually

06/06/14

4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

06/06/14

4

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

06/06/14

4

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Form as per Dwg D3304

Ensure that bend radius does not fall into straight section using DT8756.

2- Drill as per Dwg D3304 using drill Jig D3304-T1

3- Cut tube to length as per Dwg D3304

4- Deburr

06-10-06

4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26693

Part Number: D3304043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 06/10/23

7.0

D33047

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

Pick:

Qty Part Number Description

Batch

1 D3304-7 Bracket

B25067

PD 06-10-24

(4)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004 using DT8775

PD 06-10-24

(4)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06/10/25 (4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

YL 06/10/26 x4

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 06-10-26

12.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIP PIN

Pick:

Qty Part Number Description

Batch

1 BLBS-0016 Pip Pin

M100726

FF 06-10-26

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 20 Date: 06/10/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26693

Part Number: D3304043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Loop Sleeve

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M100644

FF 06-10-26

4

14.0

CBL1240

Cable



Comment: Qty.: 1.0416 f(s)/Unit Total : 4.1664 f(s)

Cable

Pick:

Qty	Part Number	Description	Batch
12.5"	CBL-1240	Cable	M102439

FF 06-10-26

4

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

Identify as D3304-043

FF 06-10-26

4

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/27

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

06/10/27 (4)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/27 (4)

Job Completion



U 06.10.27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

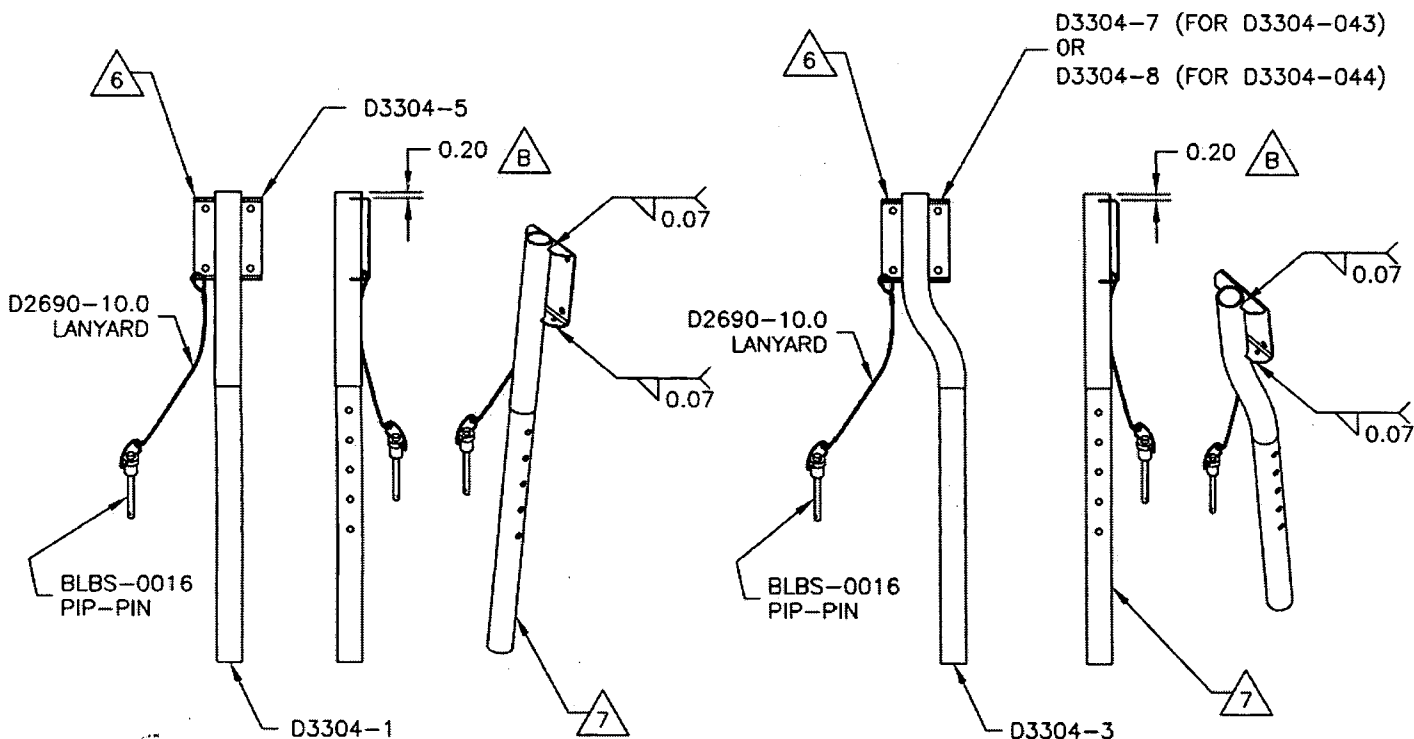
**NOTE:** Date & initial all entries



**DART**

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3304
DATE	05.07.15			TITLE TUBE ASSEMBLY
	A	04.08.18	NEW ISSUE	REV. B
	B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8	SHEET 1 OF 4
				SCALE 1:6

RELEASED  
05-08-11



**D3304-041 TUBE ASSEMBLY**

**D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE**

**D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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WORK ORDER  
NO. 26693

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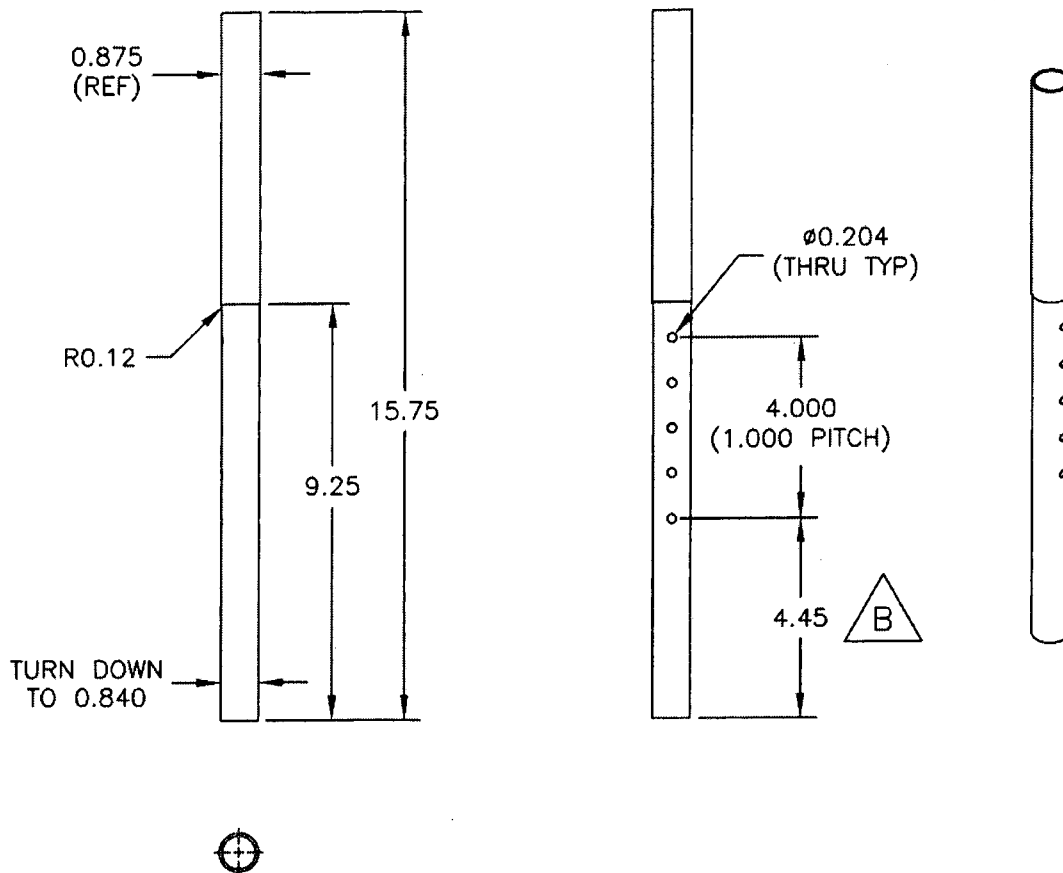
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

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05-08-11 *[Signature]*



### D3304-1 TUBE



#### D3304-1 NOTES:

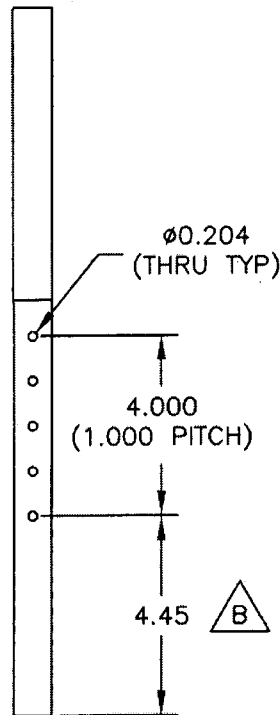
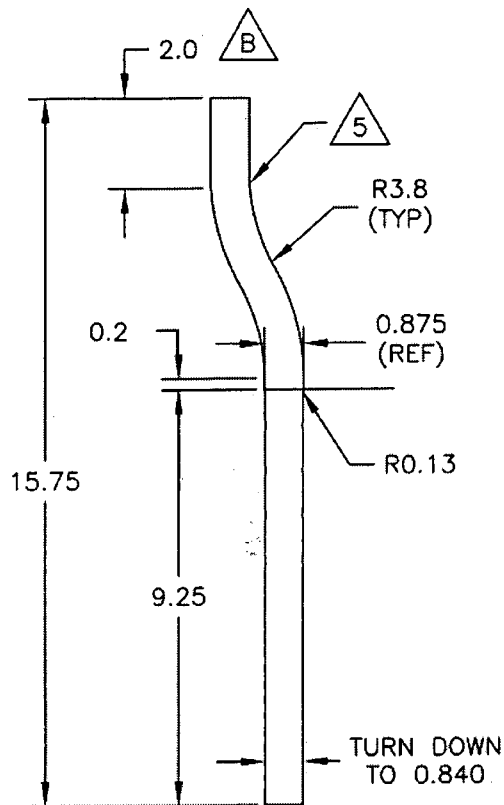
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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NO. 26693

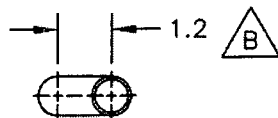
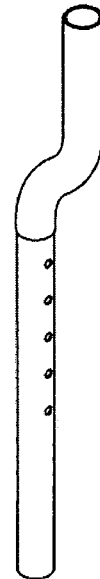
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



RELEASED  
05-08-11 *g*



**D3304-3 TUBE**

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
5) BEND LINES 9.625, 13.375 DIMENSIONS

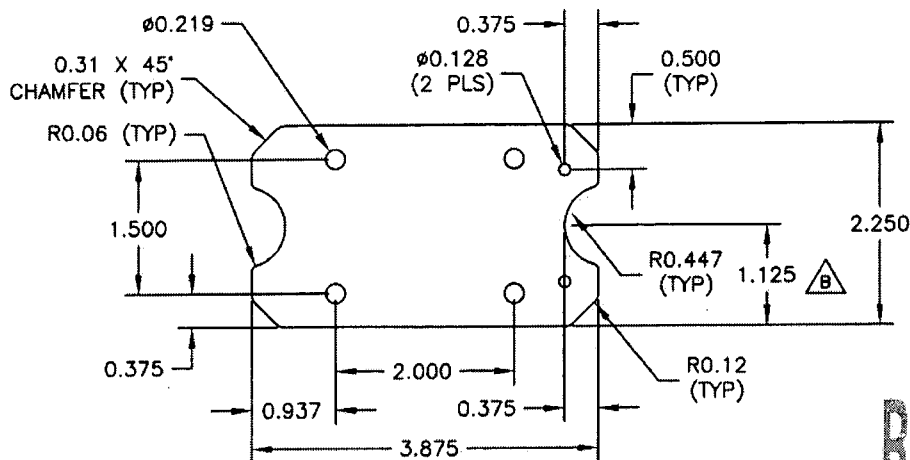
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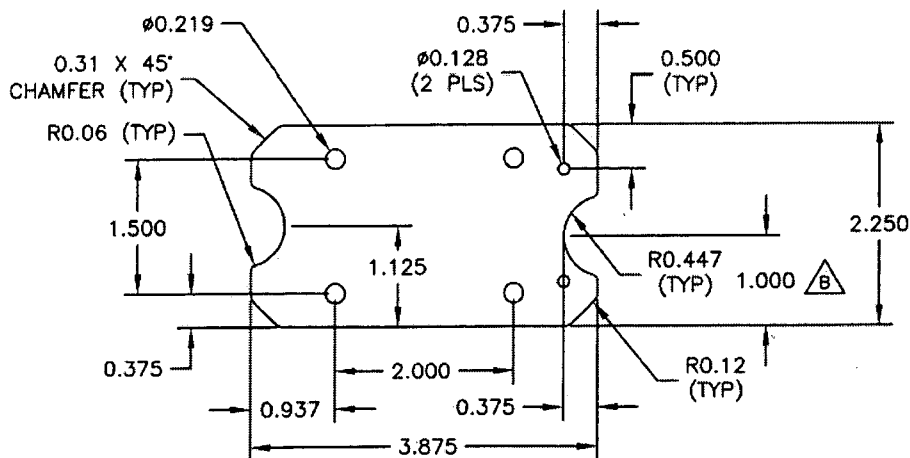


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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2

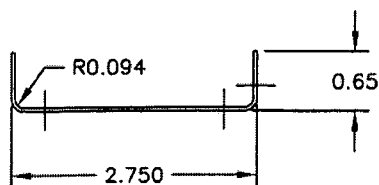


**D3304-5 FLAT PATTERN**

RELEASED  
05.08.11



**D3304-7/-8 FLAT PATTERN**



**D3304-5/-7 BRACKET  
D3304-8 OPPOSITE**

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WORK ORDER

NO. 26693

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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